

40

27

DART AEROSPACE LTD	Work Order:	19673
Description: Chafing Shield	Part Number:	D3189-1
Dwg: D3189 Rev. A	Qty:	12
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	(H)	03.09.22	12
2	GA	Cut blank: 11.25" x 4.13" Material: AISI 304/316 SS 0.020" thick sheet (M304S25GA) Batch: M2070	SB	03/10/01	12
3	GA	Grind corner as per Dwg D3189	SB	03/10/01	12
4	GA	Deburr	SB	03/10/01	12
5	GA	Roll as per Dwg D3189 Send to GREYHAWK for rolling PO# 2005749	U1	03-10-20	12
6	QC5	Inspect work to Step #5	(B)	03-11-08	12
7	LG	Identify and Stock	(D)	03-11-10	12
8	AC	Cost / part 12.18	SGC	03-11-11	12
9	DC	Close W/O 10.83 Inspect Level 21	(H)	03.11.11	12

Rev	Date	Change	Revised By	Approved
A	03.05.15	New issue	KJ/RF	(H)

Receiving - 03-10-22 (D) — 12 pcs

RELEASED  
03.05.20 RF

1.93

Dart Aerospace Ltd

Work Order:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE							
DATE	STEP	Description of NC section A	Corrective Action Section B			Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial						

PAR#: \_\_\_\_\_ Fault Category: \_\_\_\_\_ DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries  
H:\Admin-QA\ISO\forms\w\oncB.doc

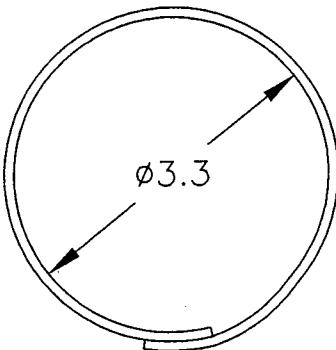
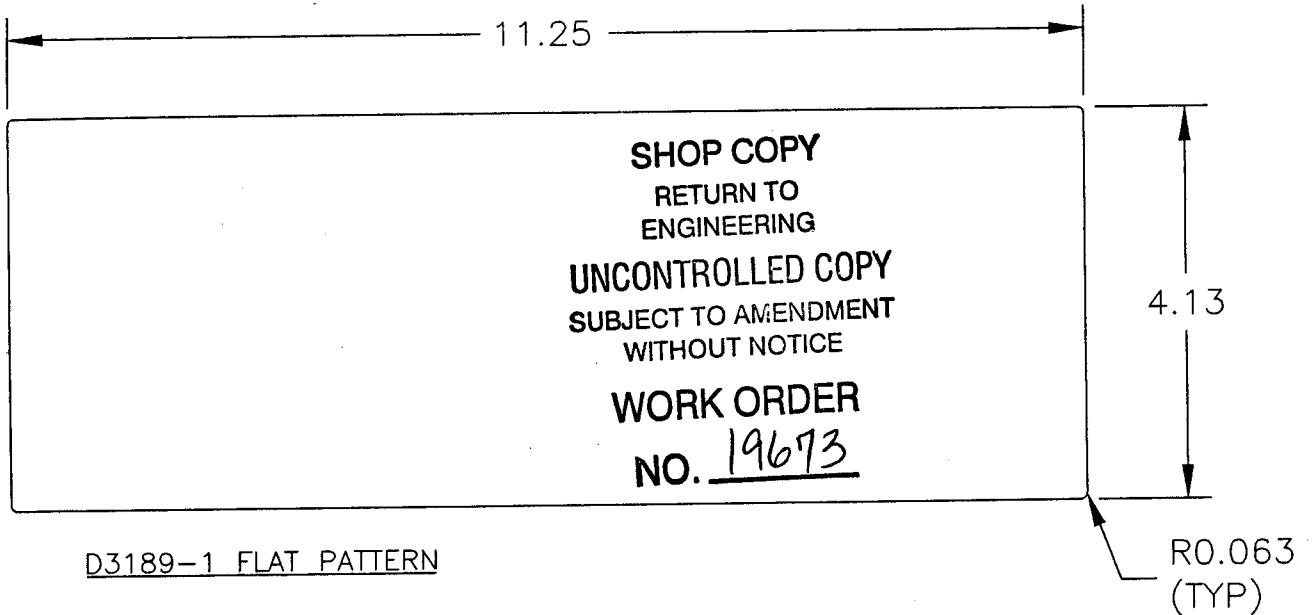
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



© COPY ISSUED  
2008

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D3189	SHEET 1 OF 1
DATE	TITLE		SCALE
03.05.08	CHAFING SHIELD		1:2
A	03.05.08	NEW ISSUE	

RELEASED  
03.05.08



D3189-1 ROLLING DETAIL  
NOT TO SCALE

D3189-1 CHAFING SHIELD

- 1) MATERIAL: AISI 304/316 SS 0.020" THICK (REF. DART SPEC M304S25GA)
- 2) FINISH: NONE
- 3) DEBURR/BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

## Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Sep 22, 2003  
01:05 pm

Work Order No : 0019673  
 Project Name : D3189-1  
 Project For : WK340  
 Work Order Type : Main  
 Main WO Number :  
 House Part Number : D3189-1  
 Description : Chafing Shield  
 Manufactured : Yes  
 Amount Req'd : 12  
 Amount Done : 0  
 Start Date : 09-22-03  
 Est Finish Date : 10-02-03  
 Act Finish Date :  
 Drawings Reqd : No  
 Ok for Approval :  
 Approval Rec'd : \$0 Posted to Finished Goods

Department Code:  
 Burden Flags : NNNNNNN  
 WO Status : Open  
 Invoice State : Not Invoiced  
 Invoice Date :  
 Invoice Number :  
 Invoice Amount : 0.00

Order Entry No :  
 OE Value : 0.00

Est Margin : 0.000%  
 Actual Margin : 0.000%

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Testing Hours :	0.00	0.00	0.00		
Testing Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
SubContract Hours :	0.00	0.00	0.00		
SubContract :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/ (Loss) :	0.00	0.00